

Date: Friday, 04/04/2008 9:58:54 AM  
 User: Julie Lecocq

## Process Sheet

<b>Customer</b>	: CU-DAR001 Dart Helicopters Services	<b>Drawing Name</b>	: WEARSHOE
<b>Job Number</b>	: 38409		
<b>Estimate Number</b>	: 12786		
<b>P.O. Number</b>	:	<b>Part Number</b>	: D35645
<b>This Issue</b>	: 04/04/2008	<b>S.O. No.</b>	:
<b>Prsht Rev.</b>	: NC	<b>Drawing Number</b>	: D3564 REVD
<b>First Issue</b>	: 04/04/2008	<b>Project Number</b>	: N/A
<b>Previous Run</b>	: 38297	<b>Drawing Revision</b>	: D
	<b>Type</b> : SMALL /MED FAB	<b>Material</b>	:
<b>Written By</b>	:	<b>Due Date</b>	: 16/04/2008
<b>Checked &amp; Approved By</b>	: <u>JL 08.04.4</u>	<b>Qty:</b>	20
<b>Comment</b>	: Est Rev:A New Issue 07-03-08 ec	<b>Um:</b>	Each
	Est Rev:B As per Rev C 07-07-09 JLM		
	Est Rev:C As per Rev D 07-09-09 JLM Verified By:EC		

## Additional Product

Job Number:



<b>Seq. #:</b>	<b>Machine Or Operation:</b>	<b>Description :</b>
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1.0	M304S16GA	304/316 .063 Sheet
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**Comment:** Qty.: 1.5750 sf(s)/Unit Total : 31.5000 sf(s)  
 M304S16GA Stainless steel sheet 0.063" thick  
 Batch: 10753 B 8-4-7

2.0	WATER JET	FLOW WATER JET
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**Comment:** FLOW WATER JET  
 1-Cut as per Dwg D3564  
 Dwg Rev: D  
 Prog Rev: D

B 8-4-7(20)2-Deburr if necessary B 8-4-7

3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
-----	-----	--



**Comment:** INSPECT PARTS AS THEY COME OFF MACHINE

B 8-4-7

4.0	QC8	SECOND CHECK
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**Comment:** SECOND CHECK

08/04/17 (20)

5.0	BRAKE NC	NC BRAKE
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**Comment:** NC BRAKE  
 Deburr if necessary  
 Form on Brake as per Dwg D3564 using Jigs DT and DT

8758155SB 08/04/17 (20)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Friday, 04/04/2008 9:58:54 AM  
User: Julie Lecocq

## Process Sheet

30 min.

18/04/2008

S.059 06.38

#1 287.3 F

B.38409 F

D.35645 F

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: WEARSHOE

Job Number: 38409

Part Number: D35645

Job Number:



Seq. #:

Machine Or Operation:

Description :

Form Joggle as per Dwg D3564 on brake using Jig DT

8157

SR 08/04/17 (20)

6.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

Ensure joggle as per dwg D3429

SR 08/04/17 (20)

7.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat Grey Sandtex (Ref: 4.3.5.6) as per QSI 005 4.3

M 106442

BR 08-04-18

(20)

8.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

FZ 08/04/18 (20)

9.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: FP-18

FZ 08/04/18 (20)

10.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

08/04/21

Job Completion



MF 08-04-18

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

<b>DART AEROSPACE LTD</b>		<b>Work Order:</b>	38409
<b>Description:</b> Wearshoe		<b>Part Number:</b>	D3564-5
<b>Inspection Dwg:</b> D3564	<b>Rev:</b> D	Page 1 of 1	

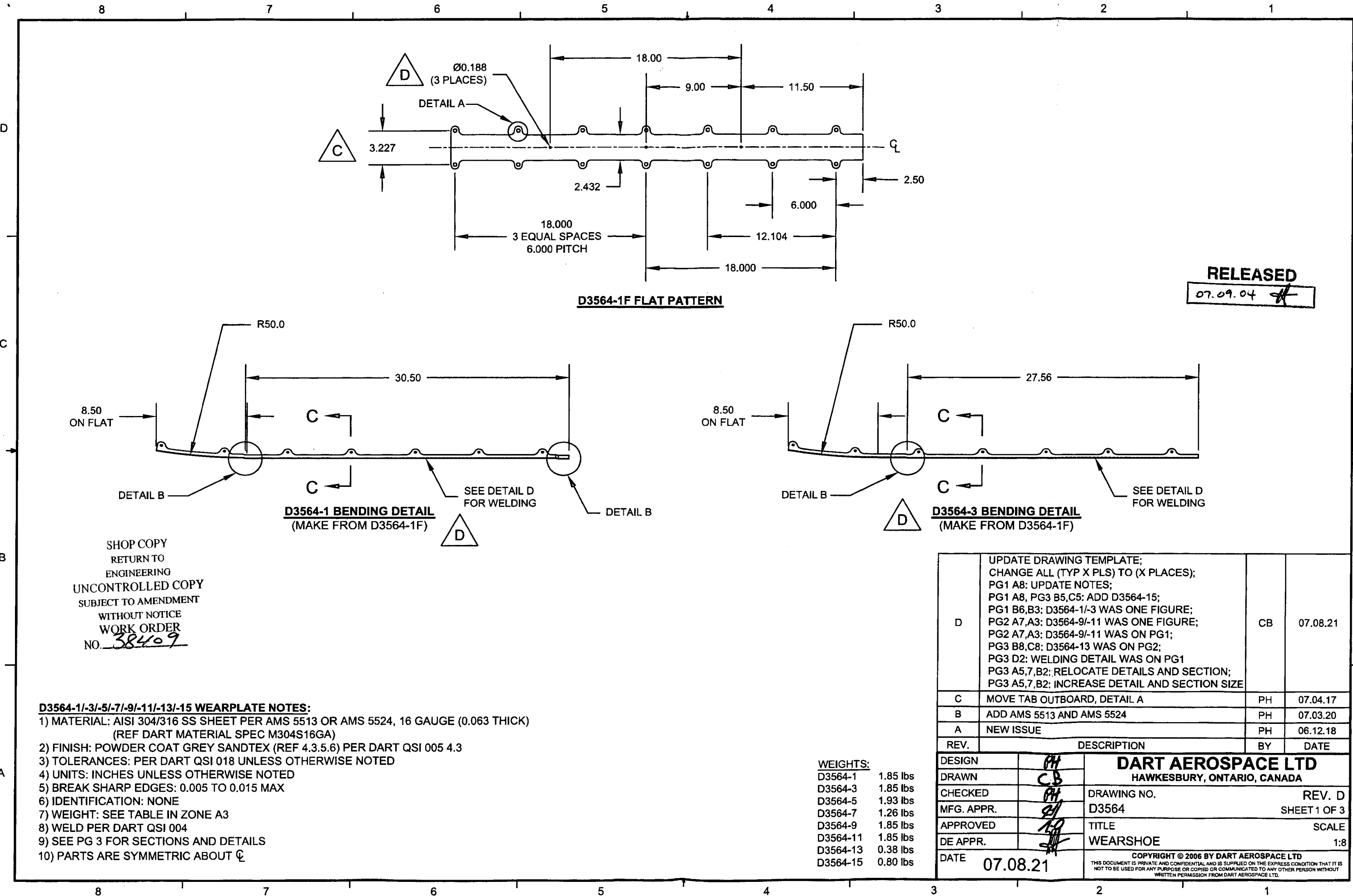
### FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
43.50	+/-0.030	43.50	*			
6.75	+/-0.030	6.75	*			
10.00	+/-0.030	10.00	*			
20.00	+/-0.030	20.00	*			
30.00	+/-0.030	30.00	*			
2.50	+/-0.030	2.50	*			
3.227	+/-0.010	3.251	*			
38.500	+/-0.010	38.500	*			
5.500	+/-0.010	5.500	*			
2.50	+/-0.030	2.50	*			
2.432	+/-0.010	2.435	*			
0.300 x 0.300	+/-0.010	.303X.303	*			
Ø0.188	+0.005/-0.001	.191	*			
R0.375	+/-0.010	.375	*			
0.063	+/-0.010	.058	*			

<b>Measured by:</b> RB	<b>Audited by:</b> [Signature]	<b>Prototype Approval:</b>	N/A
<b>Date:</b> 8-4-7	<b>Date:</b> 08/04/07	<b>Date:</b>	N/A

Rev	Date	Change	Revised by	Approved
A	08.01.16	New Issue	KJ/EC/DD [Signature]	[Signature]



8

7

6

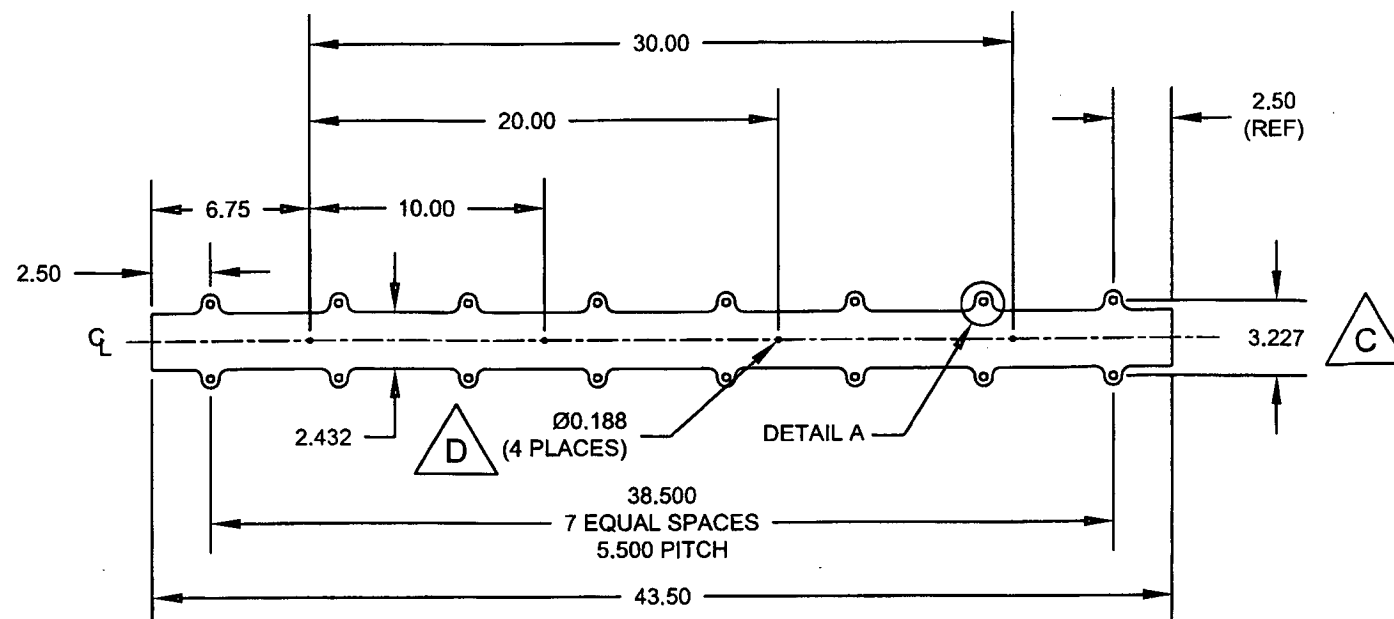
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4

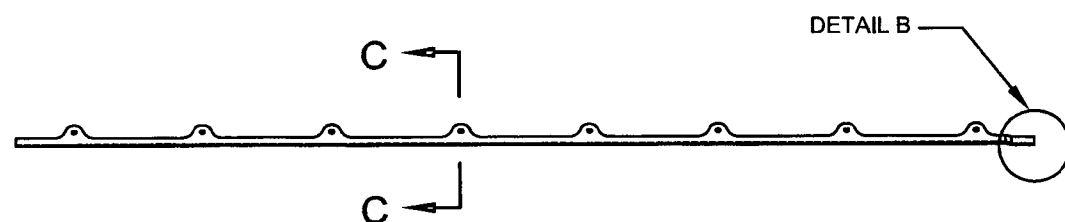
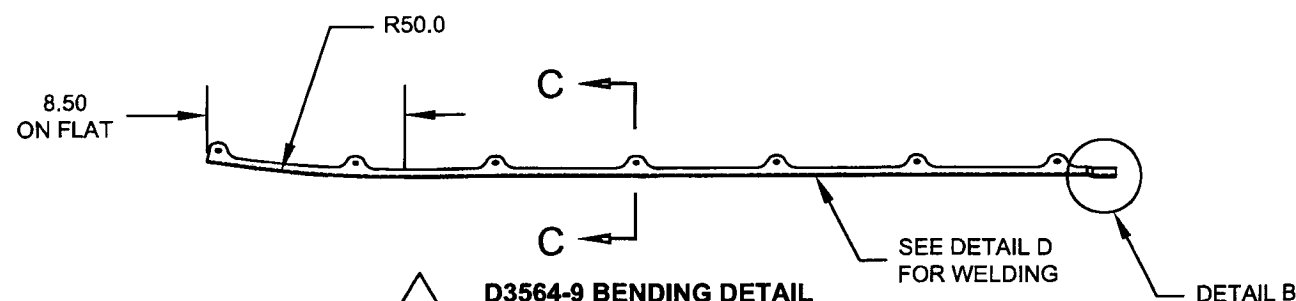
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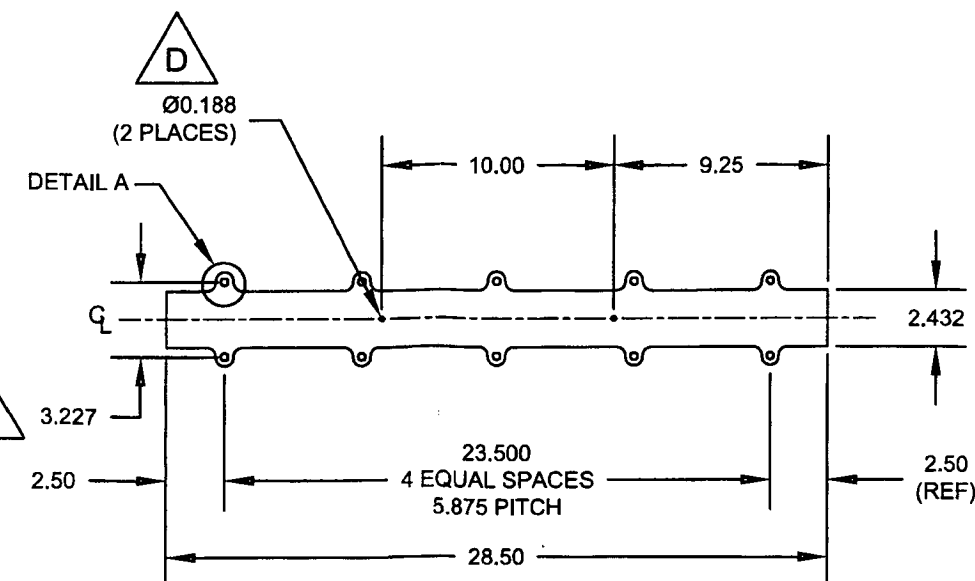
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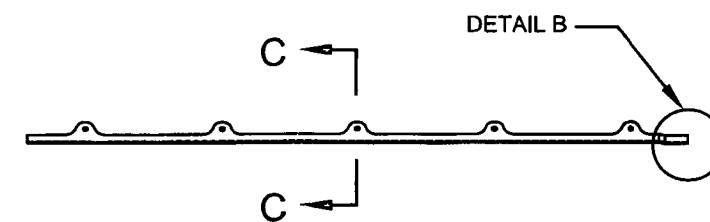
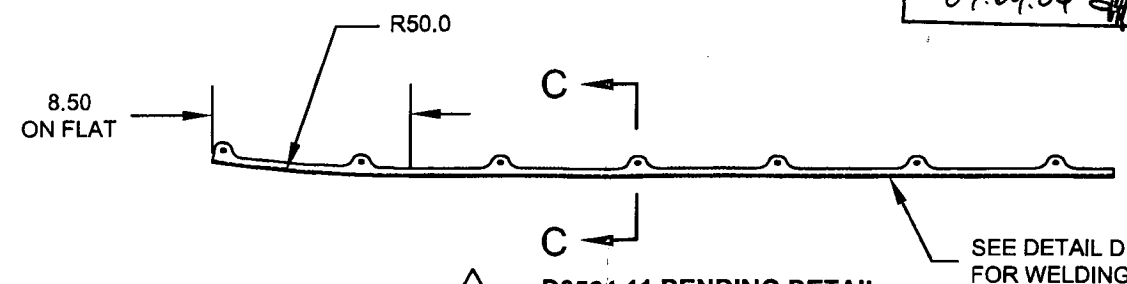
D3564-5F FLAT PATTERN

D3564-5 BENDING DETAIL  
(MAKE D3564-5 FROM D3564-5F)D3564-9 BENDING DETAIL  
(MAKE FROM D3564-1F)

SHOP COPY  
RETURN TO  
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SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. 38409



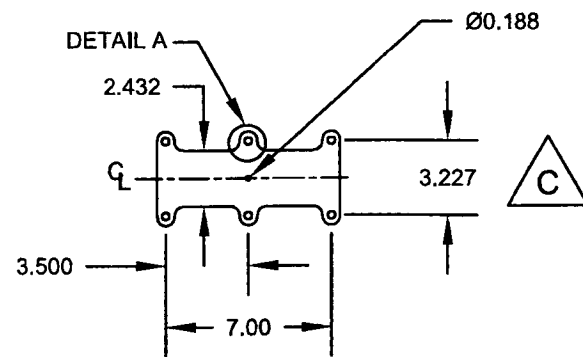
D3564-7F FLAT PATTERN

D3564-7 BENDING DETAIL  
(MAKE D3564-7 FROM D3564-7F)D3564-11 BENDING DETAIL  
(MAKE FROM D3564-1F)

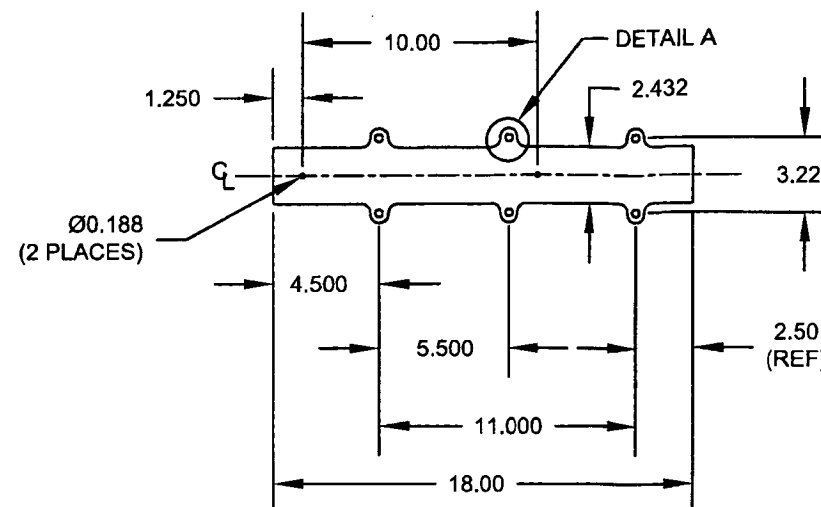
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07.09.04

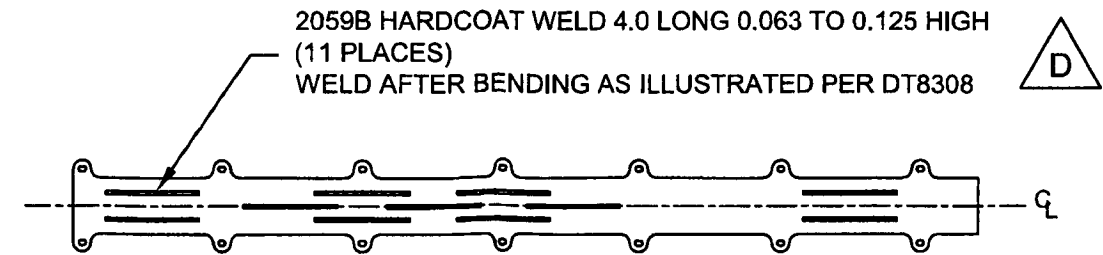
DESIGN	PH	DART AEROSPACE LTD	
DRAWN	CB	HAWKESBURY, ONTARIO, CANADA	
CHECKED	PH	DRAWING NO.	REV. D
MFG. APPR.	PH	D3564	SHEET 2 OF 3
APPROVED	PH	TITLE	SCALE
DE APPR.	PH	WEARSHOE	1:8
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**D3564-13F FLAT PATTERN**

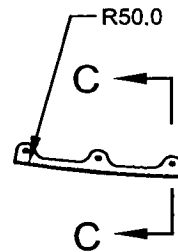


**D3564-15F FLAT PATTERN**

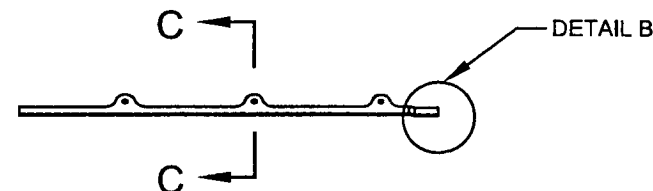


**DETAIL D**  
(D3564-1/-3/-9/-11 WELDING DETAIL)

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WITHOUT NOTICE  
WORK ORDER  
NO. 38409



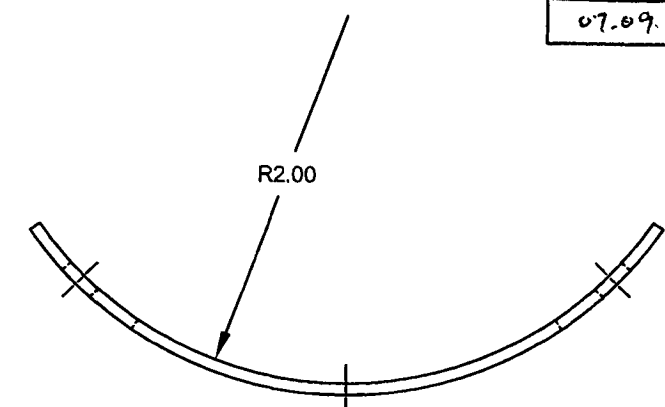
**D3564-13 BENDING DETAIL**  
(MAKE D3564-13 FROM D3564-13F)



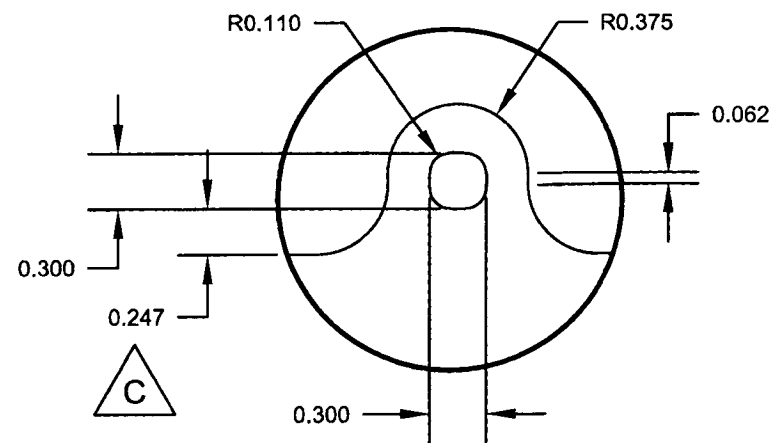
**D3564-15 BENDING DETAIL**  
(MAKE D3564-15 FROM D3564-15F)

RELEASED

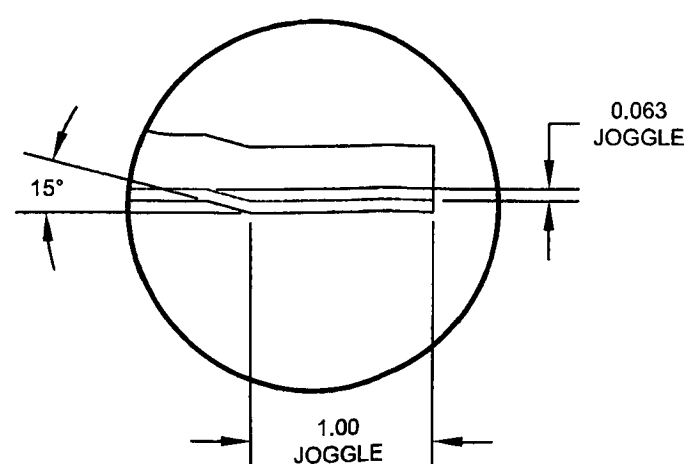
07.09.04



**SECTION C-C**  
SCALE 1:1



**DETAIL A**  
SCALE 1:1



**DETAIL B**  
SCALE 1:1

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